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D2946-041
Job Sheet 201430



Part No: D2946-041

Job Qty: 2 pcs

Part Name: Step (AS350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/3/19

Job Tracking No:

Due Date: 10/16/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: D2946 REV.C IPP REV:A 18.04.20 NEW ISSUE DD VERF:JFS IPP REV.B 18/08/02 AS PER DWG REV:C
JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	2 pcs	10/16/19		0.00	0.50	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 5	2 pcs	10/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		

130 Large Fab - Steps - 2 - B4B	2 pcs	10/16/19	0.00 2.50	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
135 QC 9	2 pcs	10/16/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DAS 24
				QC 9 - 43	9-89
				QC 9 - 50	
				QC 9 - 9	
140 QC 5	2 pcs	10/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	24
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
145 Handfinish - 1-1 Chemical- B4B	2 pcs	10/16/19	0.00 0.33	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	

155 QC 7	2 pcs	10/16/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	DAS 24 9-89
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
180 Large Fab - Steps - 3 - B4B	2 pcs	10/16/19	0.00 0.67	Large Fab - 1 - B4B	SL
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
190 QC 9	2 pcs	10/16/19	0.00 0.00	QC 9 - 10	DAS 24 9-89
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
200 QC 5	2 pcs	10/16/19	0.00 0.00	QC 5 - 10	DAS 24 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	

					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210	Handfinish - 1-2- Chemical-B4B	2 pcs	10/16/19	0.00 0.20	Handfinish - 1 - 1 - B4B	BEB 19-10-10.
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
220	Powdercoat - 1 White Gl(A)-B4B	2 pcs	10/16/19	0.00 0.50	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BA 19-10-11.
					Powdercoat - 4 - B4B	
230	Handfinish - 3-1- WingWalk-B4B	2 pcs	10/16/19	0.00 0.61	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	BEB 19-10-11
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
240	QC 3	2 pcs	10/16/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	

				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
270	Packaging 3-1 - Stock - B4B	2	10/16/19	0.00 0.00	Packaging 3 - 1 - B4B
	pcs				Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
280	QC 21 - FG	2	10/16/19	0.00 0.00	QC 21 - FG - 21
	pcs				QC 21 - FG - 70
					QC 21 - SA - 53

DAS
78
9-89

OCT 15 2019

OCT 29 2020 DAS
70
9-89

Part Op 110 - (Fabricate per Drwg) 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill hole and C'sink as per Descriptions: dwg. 3-Debur **Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.**

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Weld per dwg A/R Aluminum rod Batch: M13901-2) 1-Debur and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/R Aluminum Rod 3-Grind End Cap welds flush

135 - (QC9- Inspect visual per QSI004- Fusion Welds)

140 - (QC5- Inspect part completeness to step on W/O)

145 - (Chemical Conversion Coat per QSI005 4.1)

155 - (QC7-Inspect Chemical Conversion Coat)

180 - (Weld per dwg A/R Aluminum rod Batch: M13901-2) 1- Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. A/R AL ROD BATCH: 3300245 2- Plug hole with rivet after welding as per Dwg (Note 10)

190 - (QC9- Inspect visual per QSI004- Fusion)

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Chemical Conversion Coat per QSI005 4.1)

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

230 - (Wing Walk as per dwg QSI005 4.4 Batch 3300245)

240 - (QC3- Inspect Part Finish)
 270 - (Identify as per dwg & Stock Location: _____)
 280 - (QC21- Final Inspection - Work Order Release)

WRONG
QUANTITY

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 pcs (.5 ea)	110-Large Fab - Steps - 1	① S205619
D2734	Step End Plate	4 pcs (2 ea)	130-Large Fab - Steps - 2 - B4B	S204368 / S204372
D2944	Step Mounting Plate	4 pcs (2 ea)	130-Large Fab - Steps - 2 - B4B	S198436
MS20601-AD4W2	Rivet	2 Ea (1 ea)	180-Large Fab - Steps - 3 - B4B	S216252

Job Allocations

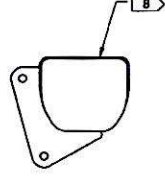
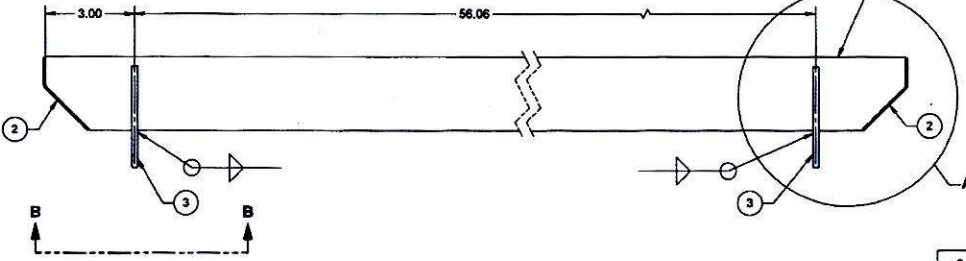
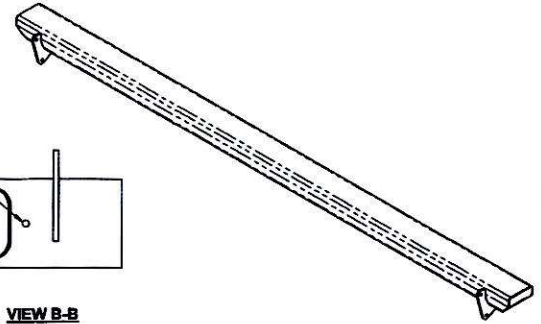
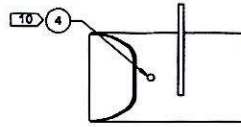
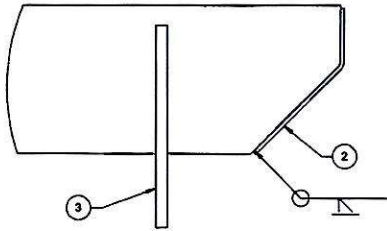
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	1	69	0
130-Large Fab - Steps - 2 - B4B	D2734	4	29	0
	D2944	4	5	0
180-Large Fab - Steps - 3 - B4B	MS20601-AD4W2	2	127	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Mounting Plate	0.257Inches + 0.006 - 0.001	0.263 0.256		Diameter
2	Step Mounting Plate	0.559Inches ± 0.010	0.569 0.549		
3	Step Mounting Plate	3.040Inches ± 0.030	3.070 3.010		
4	Step Mounting Plate	1.950Inches ± 0.030	1.980 1.920		
5	Step Mounting Plate	0.852Inches ± 0.010	0.862 0.842		
6	Step Mounting Plate	2.715Inches ± 0.001	2.716 2.714		
7	Step Mounting Plate	3.400Inches ± 0.030	3.430 3.370		

w/o 20430

ITEM	QTY	PN	DESCRIPTION
	X	D2946-041	STEP ASSEMBLY
1	1	D2946-1	STEP
2	2	D2734	END PLATE
3	2	D2944	STEP MOUNTING PLATE
4	1	MS20501AD4W2	RIVET, BLIND, CSK (OPTIONAL)



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 4.76 lbs
 - 8) APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS
 - 9) WELD PER QSI 004
 - 10) PLUG WITH MS20501AD4W2 RIVET AFTER WELDING PRIOR TO FINISH

D2946-041 STEP ASSEMBLY

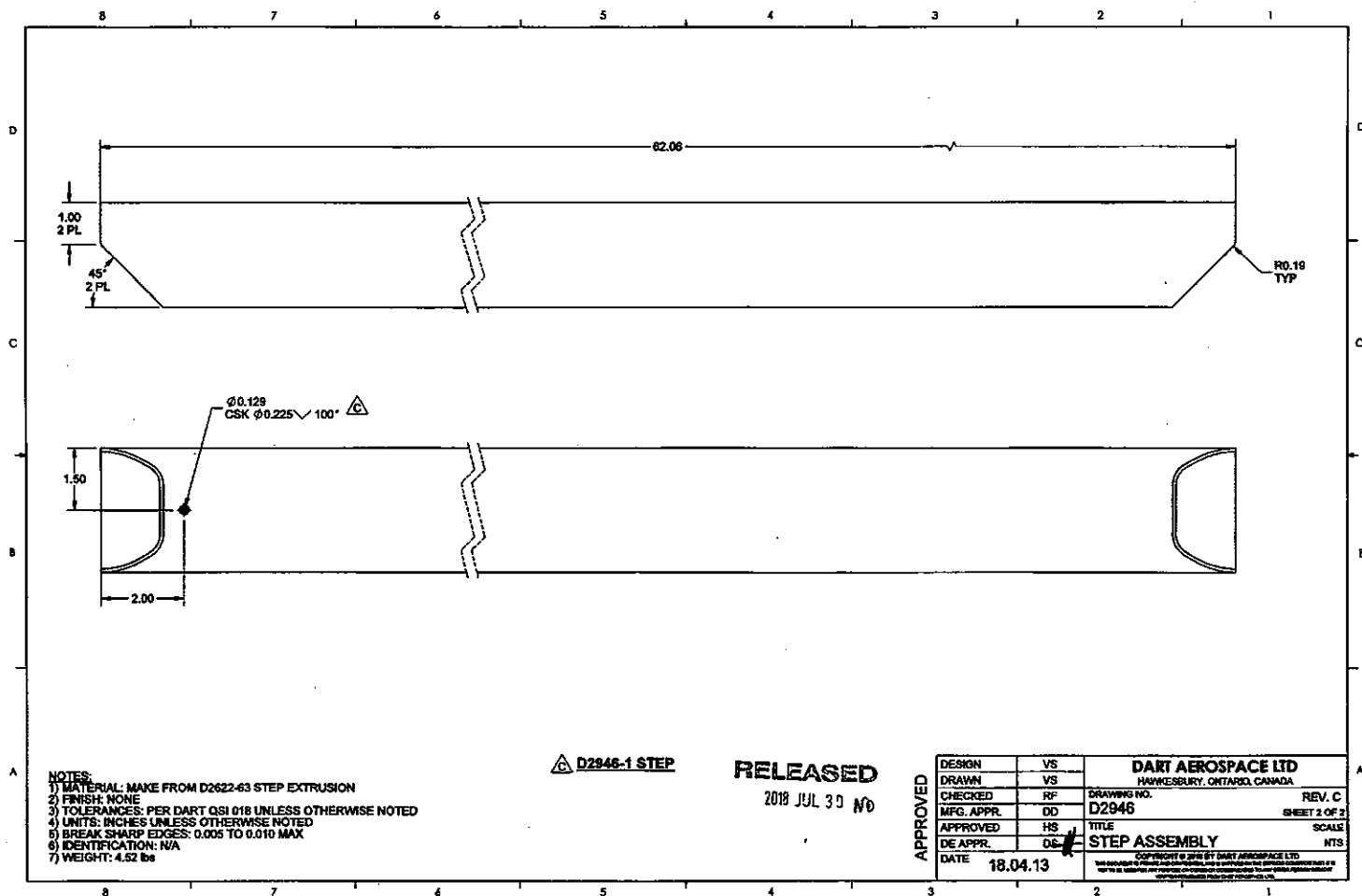
RELEASED
2018 JUL 30 NO
ECN16-749

C	REFORMAT DRAWING, ADD VENT HOLE FOR WELDING (NOTE 10), REF CIR17-103	VS	18.04.13
B	UPDATE FINISHING NOTE	PH	05.11.14
A	NEW ISSUE	CP	02.12.13
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	DD		
APPROVED	HS		
DE APPR.	DS		
DATE	18.04.13		

DART AEROSPACE LTD
HAMMERSBURY, ONTARIO, CANADA

DRAWING NO. D2946
TITLE STEP ASSEMBLY
REV. C
SHEET 1 OF 2
SCALE NTS

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Container No: S220240



Part: D2946-041

Job No: 201430

Serial No/Batch: S220240

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/07/19

